

Work Order ID 80967

March-06-12 8:58:27 AM

LH

80967

Page 1

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 06/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 12/03/06 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A [Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number DescriptionBatch

A/R Aluminum Rod *M120164/M120854*

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 & DT8169D & DT9771.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

Rm 12-5-9

BE 12-05-14

Rm 12-5-15

SAD 12-05-29

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Run Start ***NR1***

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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

SAD
12-05-07
8/21/13

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00				1	786	12-5-30	
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00				1	0	12-05-30	
Quality Control									
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

DL 12/05/30

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170 QC6- Inspect dimensions to drawing 0.00

170

QC

Memo

0.00

Quality Control

JD 12-5-30

180 Skidtubes 0.00

180

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 12/05/30 Time: 4:15
Finish Date: 12/06/01 Time: 7:00

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 12/221

Sikaflex expire date: 13/01/04

DC 12/05/30

W/O:		WORK ORDER CHANGES					
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1

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1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

1

0

86 12/06/01

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Start Date: 06/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 20/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

200

Skidtubes

0.00

Skidtubes

Skidtubes

Memo

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod M100/64

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE BE 12/06/07

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

BE 12/06/01

BE 12/06/06

DP / SPO

12-6-7

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00

230

QC

Memo

0.00

Quality Control

240

Pressure Wash per QSI005 4.3

0.00

240

HandFinish

Memo

0.00

Hand Finishing

250

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

250

Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:45
320 OF
9:15

M121134

~~1 NG 12-6-11~~

1 NG 12-6-11

1X ~~NG~~ 12/06/11

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC3- Inspect Part Finish	0.00							
260									
QC	Memo	0.00							
Quality Control									
270		0.00							
270	HandFinishing								
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								

164 d 2012/06/13

164 2 20 12/07/27

W/O:		WORK ORDER CHANGES					
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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	HandFinishing	0.00							
280									
HandFinish	Memo	0.00							
Hand Finishing	1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 <u>122130</u> Sikaflex expire date: <u>14/03</u>								
	2- Install wearplate as per dwg								
	2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: <u>121613</u>								
290	QC3- Inspect Part Finish	0.00							
290									
QC	Memo	0.00							
Quality Control									

DAS
16
9-03
176430

1 5 14/07/27

W/O:		WORK ORDER CHANGES					
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300 QC5- Inspect part completeness to step on W/O 0.00

300

QC

Quality Control

Memo

DAS 16 12/4/30

310 Packaging 0.00

310

Packaging

Packaging

Memo

Identify and pack for shipping as per PPP D206-642-151

Location:

PPP Rev:

PP 80978

320 QC21- Final Inspection - Work Order Release 0.00

320

QC

Quality Control

Memo

0.00

12/4/30

12/8/80

MF 12-08-07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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80967

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620

Manufactured No

110

Each

19.0000

1

1

D2620

Skidtube, 206 Skidtube

**

Location	Loc Qty	Loc Code
LG 80518	19	
77996	1	
77999	1	
78000	4	
79542	1	
79543	2	
79544	8	
79545	2	

① REM 12-5-9

D2647

Manufactured No

110

Each

57.0000

1

1

D2647

Cap

**

Location	Loc Qty	Loc Code
LG002	57	
75482	57	

262-05-14
B 79563 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

7,125.000

52

52

CR3212-4-04

Cherry Rivet

**

DL 12/05/30

Location

Loc Qty

Loc Code

ST331

168

116471

78

117816

3

118686

1

118840

16

119017

60

119075

10

st510

6957

119075

6957

(52)

D2654-1

Manufactured

No

180

Each

23.0000

1

1

D2654-1

Web

**

DL 12/05/30

Location

Loc Qty

Loc Code

LG

23

79540

5

79541

6

80054

2

80055

10

(1)

D3286-1

Manufactured

No

180

Each

121.0000

2

2

D3286-1

Doubler

**

SAD 12-08-07

Location

Loc Qty

Loc Code

LG002

217

74872

6

78014

93

ST046

-96

76772

22

379556

2

March-06-12 8:58:31 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-06-12 8:58:31 AM

Page 3

Work Order ID: 80967

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

80967

D206-642-151

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

1,736.000

19

19

D2649

Cross Bolt Spacer

**

8/6 12/06/01

Location

Loc Qty

Loc Code

LG

1279

77574

2

79502

403

79503

399

79504

214

79565

261

LG001

457

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

6

78583

2

79566

330

19

D3286-3

Manufactured No

200

Each

113.0000

2

2

D3286-3

Spacer

**

8/6 12/06/07

Location

Loc Qty

Loc Code

LG

9

78015

9

LG001

104

74117

1

79557

103

2

March-06-12 8:58:31 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

March-06-12 8:58:31 AM

Page 4

Work Order ID: 80967

80967

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

210 Each

158.0000 1

1

D2680-041

Nut Plate

**

Dec 12/06/07

Location

Loc Qty

Loc Code

ST013

116

78016

116

ST019

42

76790

42

CR3212-4-03

Purchased No

210 Each

1,484.000 2

2

CR3212-4-03

Cherry Rivet

**

Dec 12/06/07

Location

Loc Qty

Loc Code

FP002

494

114859

494

ST331

990

110139

2

119017

988

AN960JD416

NAS1149D0463J Purchased

No

210 Each

20.0000 1

1

AN960JD416

Washer

**

1 2P 12/06/11

Location

Loc Qty

Loc Code

ST351

20

116289

20

CCR264SS3-3

Purchased No

210 Each

723.0000 2

2

CCR264SS3-3

Cherry Rivet

**

Dec 12/06/07

Location

Loc Qty

Loc Code

ST331

723

113973

2

117849

125

119017

596

March-06-12 8:58:31 AM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-06-12 8:58:31 AM

Page 5

Work Order ID: 80967

80967

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

204.0000

1

1

MS27039-4-06

Screw

**

1

(SP)

12/06/12

Location

Loc Qty

Loc Code

ST292

204

119075 ✓

204

D2651-1

Manufactured

No

270

Each

749.0000

6

6

D2651-1

Plug

**

6

(SP)

12/06/12

Location

Loc Qty

Loc Code

FP001

884

57869

1

66445

10

69018

2

70827

2

70839

8

71037

8

77559

30

78584

245

79234

278

FP-A

-135

77559

1

78124

164

D2651-3

Manufactured

No

270

Each

2,017.000

6

6

D2651-3

O-Ring

**

6

(SP)

12/06/12

Location

Loc Qty

Loc Code

FP001

89

61962

12

73828

77

FP-A

1928

78126 ✓

1928

March-06-12 8:58:31 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

March-06-12 8:58:31 AM

Page 6

Work Order ID: 80967

80967

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

280

Each

431.0000

14

14

D3873-1

Bushing

**

14 (2P) 12/06/12

Location

Loc Qty

Loc Code

ST057

76791✓

372

79561

372

ST067

59

64760

1

68247

4

73829

19

73830

2

79560

33

D2646

Manufactured No

280

Each

50.0000

1

1

D2646

Aft Cap

**

1 (2P) 12/06/12

Location

Loc Qty

Loc Code

FP002

81974✓

50

62678

5

68280

5

70945

1

71070

2

73294

1

73825

2

78018

34

D3805-041

Manufactured No

280

Each

8.0000

1

1

D3805-041

Wearplate Assembly Fwd, Low Gear

**

1 (2P) 12/07/12

Location

Loc Qty

Loc Code

FP001

83801✓

8

76779

1

78003

7

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

March-06-12 8:58:31 AM

Page 7

Work Order ID: 80967

80967

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,243.000

2

2

MS27039-1-08

Screw

**

2

②P 12/06/12.

LocationLoc QtyLoc Code

ST291

1243

117423

81

119075

156

119109

6

120308 ✓

1000

MS21042L3

Purchased

No

280

Each

3,643.000

7

7

MS21042L3

Nut

**

7 ②P 12/06/12.

LocationLoc QtyLoc Code

ST300

3643

117441

16

117885

32

118451

5

118927

3

119017 ✓

3407

119075

180

D3805-045

Manufactured

No

280

Each

14.0000

1

1

D3805-045

Wearplate Assembly Aft, Low Gear

**

1 ②P 12/07/12

LocationLoc QtyLoc Code

FP001

14

73817

1

74896

1

78010

2

78011

10

AN960JD10L

* NAS1149D0332J Purchased

No

280

Each

0.0000

2

2

AN960JD10L

Washer

**

2 ②P 12/06/12.

March-06-12 8:58:31 AM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

March-06-12 8:58:31 AM

Page 8

Work Order ID: 80967

80967

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-37A

Purchased

No

280

Each

790.0000

7

7

AN3-37A

**

7

AP

12/06/12

Bolt

LocationLoc QtyLoc Code

ST353

790

117619

4

119086✓

786

NAS1149D0363J

Purchased

No

280

Each

2,181.000

7

7

NAS1149D0363.J

**

7

AP

12/06/12

Washer

LocationLoc QtyLoc Code

ST298

2181

117601

61

118077

1

118612

18

119537

257

120142

274

120308

570

120644

1000

121243✓

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 80967 MLJ
12/03/06

RELEASED
UP 09.03.03
PC ECN 09-538

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	97		
DRAWN			
CHECKED	97		
MFG. APPR.	97		
APPROVED	142		
DE APPR.	142		
DATE	08.07.07		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
D3804	SHEET 1 OF 5
TITLE	SCALE
SKIDTUBE ASSEMBLY, 206A/B	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

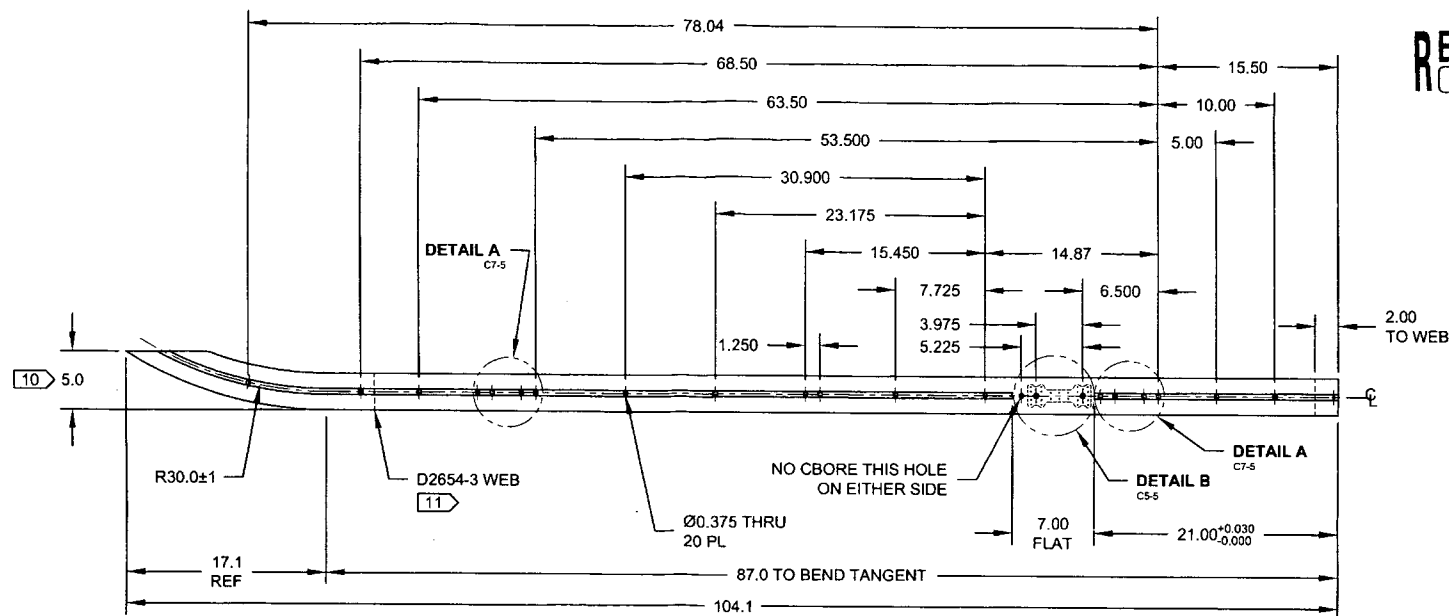
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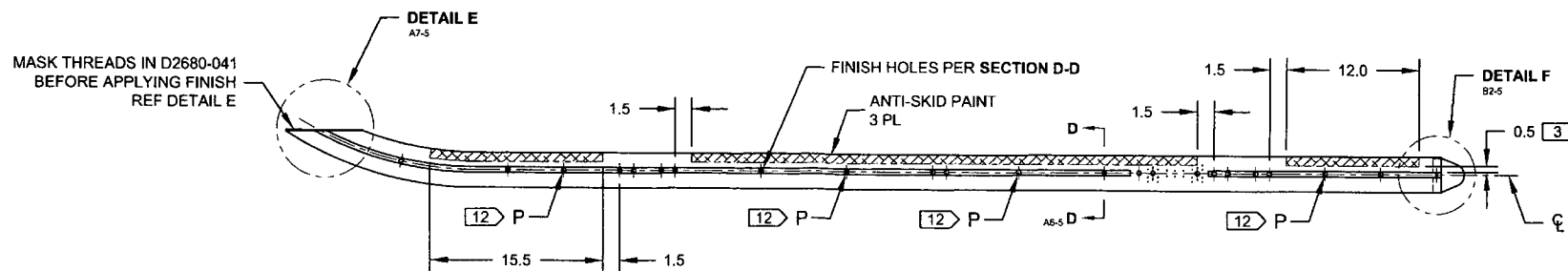
NOTE: Date & initial all entries

RELEASED
09.53.53

80967



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	7	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 3 OF 5
APPROVED	109	TITLE	SCALE
DE APPR.	11	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

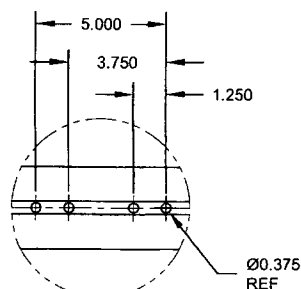
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

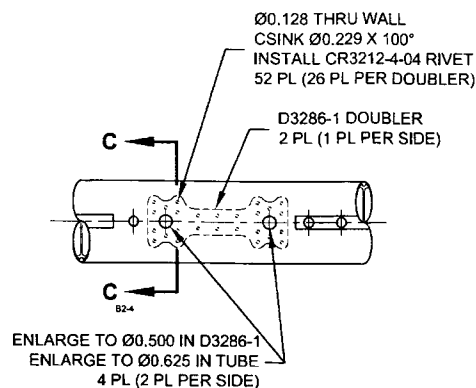
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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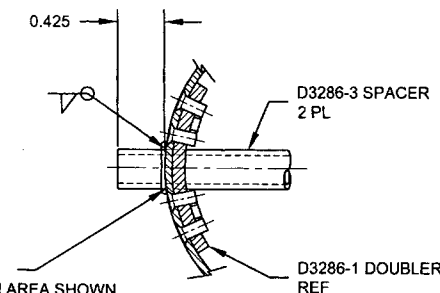
RELEASED
09.03.03



DETAIL A
D6-2
C2-2
D6-3
C2-3
SCALE NONE

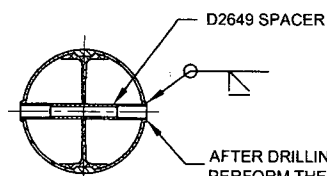


DETAIL B
C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
C6-4
PARTIAL SECTION
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D
A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	2	DRAWING NO.	REV. A
MFG. APPR.	3	D3804	SHEET 4 OF 5
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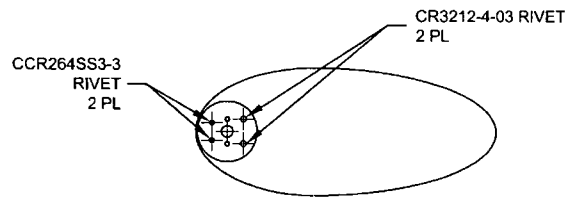
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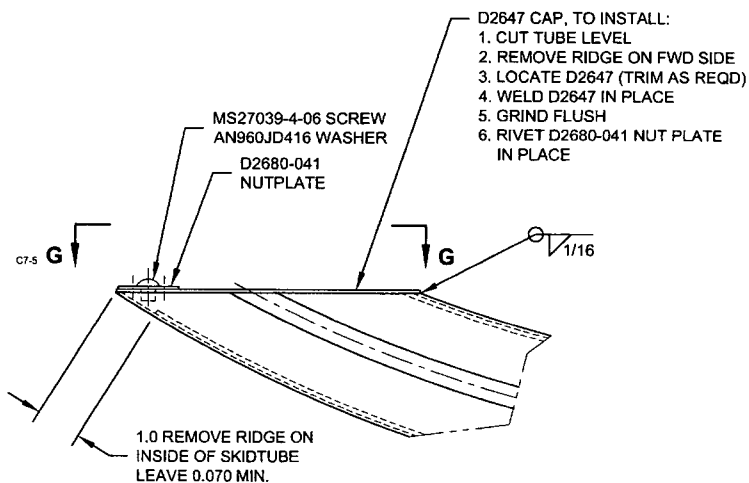
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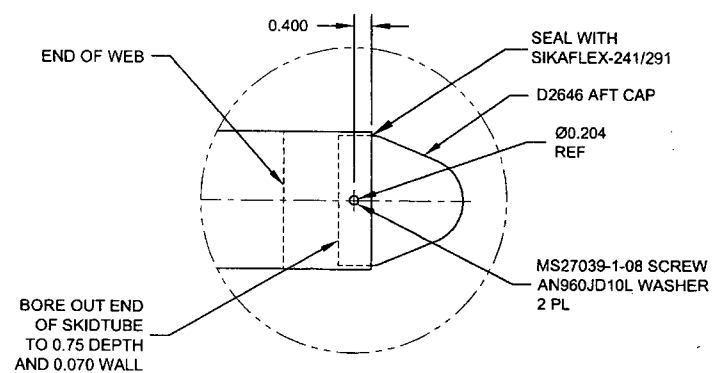
80967



VIEW G-G
 SCALE NONE



DETAIL E
 SCALE NONE



DETAIL F
 SCALE NONE

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	P	DRAWING NO.	REV. A
MFG. APPR.	E	D3804	SHEET 5 OF 5
APPROVED	12	TITLE	SCALE
DE APPR.	12	SKIDTUBE ASSEMBLY, 206A/B	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 295

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 83028
Part number: A 206-642-241
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum.
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier [Signature] Date of Test Coupon 12.05.23
Welder Barclay Elliott Date of Test Coupon 12.05.23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld